

WHAT IS CLAIMED IS:

1. A method of making a hard-sided luggage article, said method comprising using a blow molding process to produce a base and a lid for said luggage article.
- 5 2. The method of Claim 1, including said lid having a double wall construction including an outer wall and an inner wall.
- 10 3. The method of Claim 2, including forming said inner wall with intermittent portions which contact an inner surface of said outer wall in order to impart torsional and compressive strength to said lid.
- 15 4. The method of Claim 3, including said base is formed with a Z-beam to receive said lid thereon; said inner wall includes a groove section which mates with said Z-beam when said lid is received on said base; and an extrusion attached to a section of said 20 Z-beam.
- 25 5. The method of Claim 4, including said extrusion is a co-extrusion having a first portion which clips on to said section of said Z-beam and a second portion which extends laterally outwardly from said first portion.
- 30 6. The method of Claim 5, including said first portion is made from a first material and said second portion is made from a second material, said first material being harder than said second material.

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7. The method of Claim 6, including
said base and lid have a first color and
said second material has a second color, whereby said
second portion creates a color break between said base and
5 said lid.

8. A hard-sided luggage article comprising:
a base;
a lid secured to said base; and
said base including an opening defined by
10 a Z-beam.

9. The method of Claim 8, including
an extrusion attached to a section of said
Z-beam.

10. The method of Claim 9, including
15 said extrusion is a co-extrusion having a
first portion which clips on to said section of said
Z-beam and a second portion which extends laterally
outwardly from said first portion.

11. The method of Claim 10, including
20 said first portion is made from a first
material and said second portion is made from a second
material, said first material being harder than said
second material.

12. The method of Claim 11, including
25 said base and lid have a first color and
said second material has a second color, whereby said
second portion creates a color break between said base and
said lid.

13. The method of Claim 8, including
30 said lid has a double wall construction
including an outer wall and an inner wall.

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14. The method of Claim 13, including
said inner wall has intermittent portions
which contact an inner surface of said outer wall in order
to impart torsional and compressive strength to said lid.

5 15. The method of Claim 14, including
said inner wall includes a groove section
which mates with said Z-beam when said lid is closed on
to said base.

10 16. A hard-sided luggage article including a
trap-door lid.

17. The method of Claim 16, including
said luggage article including a base, said
trap-door lid being hingedly connected to said base.

15 18. The method of Claim 17, including
said lid and said base are separated by a
parting line.

19. The method of Claim 18, including
said base includes a bottom portion and a
sidewall portion; and
20 said parting line having a portion that is
not disposed on said sidewall portion.

20. The method of Claim 19, including
said portion of said parting line not
disposed on said sidewall portion is where said lid is
25 hingedly connected to said base.